

Work Order ID 147757

June 13, 2016 10:55:26 AM

U/R***147757****Bill Only*

Page 1

Item ID: D412-761-045

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-533

Item Name: Bubble Window

Stop

NS2

Start Date: 6/13/2016 Start Qty: 2.00

2

Required Date: 6/20/2016 Req'd Qty: 2.00

2*split - 1 km*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: OHDate: 6/13/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	Rev E U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-045	CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

AUG 2 6 2016

JUL 2 9 2016

AUG 2 6 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 147757

June 13, 2016 10:55:26 AM

147757

Page 2

Item ID: D412-761-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-533 Stop ***NS2***
Item Name: Bubble Window
Start Date: 6/13/2016 Start Qty: 2.00 *?
Required Date: 6/20/2016 Req'd Qty: 2.00 *?
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-045 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

Handwritten notes:
DAS 27 9-89
AUG 26 2016
DAS 21 9-89
SEP 13 2016
DAS 21 9-89
SEP 13 2016
PPP 149854

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

June 13, 2016 10:55:31 AM

147757

D412-761-045

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

P_C

DAS
28
9-89

Loc Code

2

② XB148133 PC

DAS
28
9-89

Loc Code

1

144450

DAS 6-88

AUG 15 2016
14693528
9-89

0.0000

~~B146806~~

DAS
~~28~~
9-89

JUL 9 2016

Picklist Print

June 13, 2016 10:55:31 AM

Page 2

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3678-1

Manufactured No

110

Each

7.0000

1

2

D3678-1

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

7

139501

2

145256

5

D3678-3

Manufactured No

110

Each

7.0000

1

2

D3678-3

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

7

139556

2

145257

5

D3700-1

Manufactured No

110

Each

4.0000

1

D3700-1

Inboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

4

112422

2

113719

2

D3700-3

Manufactured No

110

Each

1.0000

1

2

D3700-3

Outboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

1

113793

1

APPROX 3678-5 x1 B 148033
per ECN 16-599
MF 16-6-21

DAS
28
9-89

JUL 29 2016

JUL 19 2016

JUL 29 2016

June 13, 2016 10:55:31 AM

Shop Packet Print

Page 2

Picklist Print

June 13, 2016 10:55:31 AM

Page 3

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3701-1

Manufactured No

110

Each

3.0000

1

D3701-1

Floor Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

3

96231

3

**

2

B146 942 PC DAS 28 9-89

D3702-1

Manufactured No

110

Each

2.0000

1

D3702-1

Fwd Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st507

2

110312

2

**

2

B146 922 PC DAS 28 9-89

D3703-1

Manufactured No

110

Each

8.0000

1

D3703-1

Aft Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

ST512

8

113680

8

**

2

PC DAS 28 9-89

D3703-3

Manufactured No

110

Each

11.0000

1

D3703-3

Aft Corner Doubler

DAS
27
9-89

Pull from
Pat Duvals
Office

Location

Loc Qty

Loc Code

Quarantine

6

146153

6

st239

5

112397

2

113705

3

**

2

B148 973 PC DAS 28 9-89

JUL 29 2016

Picklist Print

June 13, 2016 10:55:31 AM

Page 4

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3703-5

Manufactured No

110

Each

1.0000

1

D3703-5

Aft Cap

DAS
27
9-89

Location

Loc Qty

Loc Code

ST052

1

112542

1

**

② X B146 016 P DAS 28 9-89

D3704-1

Manufactured No

110

Each

11.0000

1

D3704-1

Escutcheon

DAS
27
9-89

Location

Loc Qty

Loc Code

ST052

11

112406

2

146856

9

**

PC DAS 28 9-89

D3708-1

Manufactured No

110

Each

2.0000

1

D3708-1

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

2

103523

2

**

② X B146 844 P DAS 28 9-89

D3708-3

Manufactured No

110

Each

2.0000

1

D3708-3

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

2

112491

2

**

② X B146 899 P DAS 28 9-89

JUL 29 2016

Picklist Print

June 13, 2016 10:55:31 AM

Page 5

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3709-1
D3709-1
Angle

Manufactured No

110 Each

1.0000

1

**

2

148015

DAS
28
9-89

DAS
28
9-89

Aug 15 2016

Location

Loc Qty

Loc Code

ST235

1

115558

1

D3709-3
D3709-3
Angle

Manufactured No

110 Each

1.0000

1

**

2

X145 TAPE

DAS
28
9-89

Location

Loc Qty

Loc Code

ST235

1

134451

1

D3802-1
D3802-1
Windows Seal (\$ Per Foot)

Manufactured No

110 f

80.1873

13.5

27

**

P

DAS
28
9-89

Location

Loc Qty

Loc Code

ST416

80.187346

141991

0.00367

143804

0.59184

146267

29.591836

147067

50

27

1- Cut one per dwg d3802-1-135

DT9458
DT9458
Cutting Template

Manufactured No

110 Each

0.0000

1

**

2

DAS
28
9-89

AN3-7A
AN3-7A
Bolt

Purchased No

110 Each

172.0000

26

52

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

ST349

172

m134606

172

52

June 13, 2016 10:55:31 AM

Shop Packet Print

Page 5

JUL 29 2016

Picklist Print

June 13, 2016 10:55:31 AM

Page 6

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

110

Each

2,264.000

52

104

NAS1149D0363J

Washer

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST263

1799

m134606

8

m134676

791

m134955

1000

MS21042L3

Purchased

No

110

Each

1,768.000

26

MS21042L3

Nut

PC 52 X N135 OS6 PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

855

m134039

12

m134634

43

m134943

800

MS24694-C5

Purchased

No

110

Each

100.0000

1

2

MS24694-C5

Screw

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST285

100

m130238

100

JUL 29 2016

June 13, 2016 10:55:31 AM

Shop Packet Print

Page 6

Picklist Print

June 13, 2016 10:55:31 AM

Page 7

Work Order ID: 147757

147757

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/13/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS24694-C13

Purchased

No

110

Each

13.0000

1

2

MS24694-C13

Screw

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST285

13

108558

13

2

JUL 29 2016

Under Review Notification

Raised By: M. BELLAVANCE

Product #: D412-761-045

Date: 16.02.25

Product Name: LARGE BUBBLE WINDOW KIT, LH

Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3703-3	D3703 Rev. B	N	Y	N	Y	N	Y	N	16-533	See below.
D412-761-045	IIN-D412-761 Rev.	N	Y	N	Y	N	Y	N	16-533	See below.

Description of Issue:

Current stock OK to ship to customers other than Bell Helicopter Mirabel.

If shipping to Bell Helicopter Mirabel: must ship D412-761-045 with D3703-3 modified as per attached. Eng. to sign off deviations on W/Os.

8 7 6 5 4 3 2 1

D

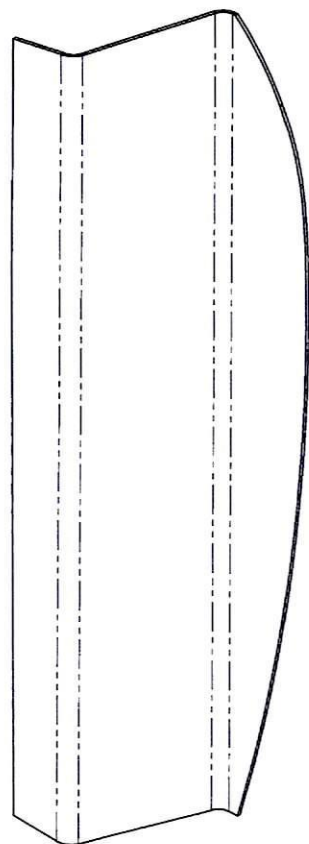
D

C

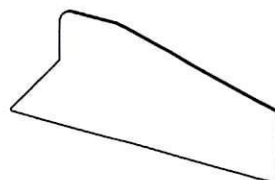
C

B

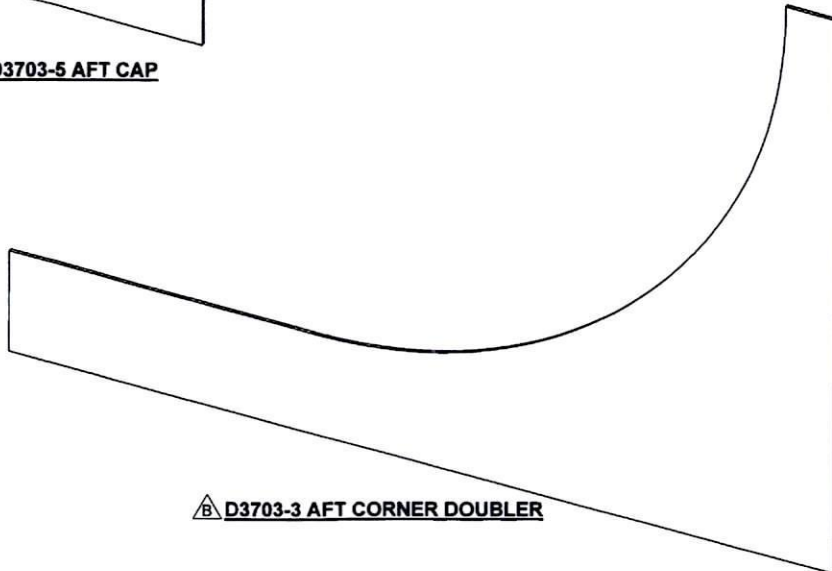
B



8 D3703-1 AFT DOUBLER



B D3703-5 AFT CAP



B D3703-3 AFT CORNER DOUBLER

RELEASED
2013-01-14

NOTES:

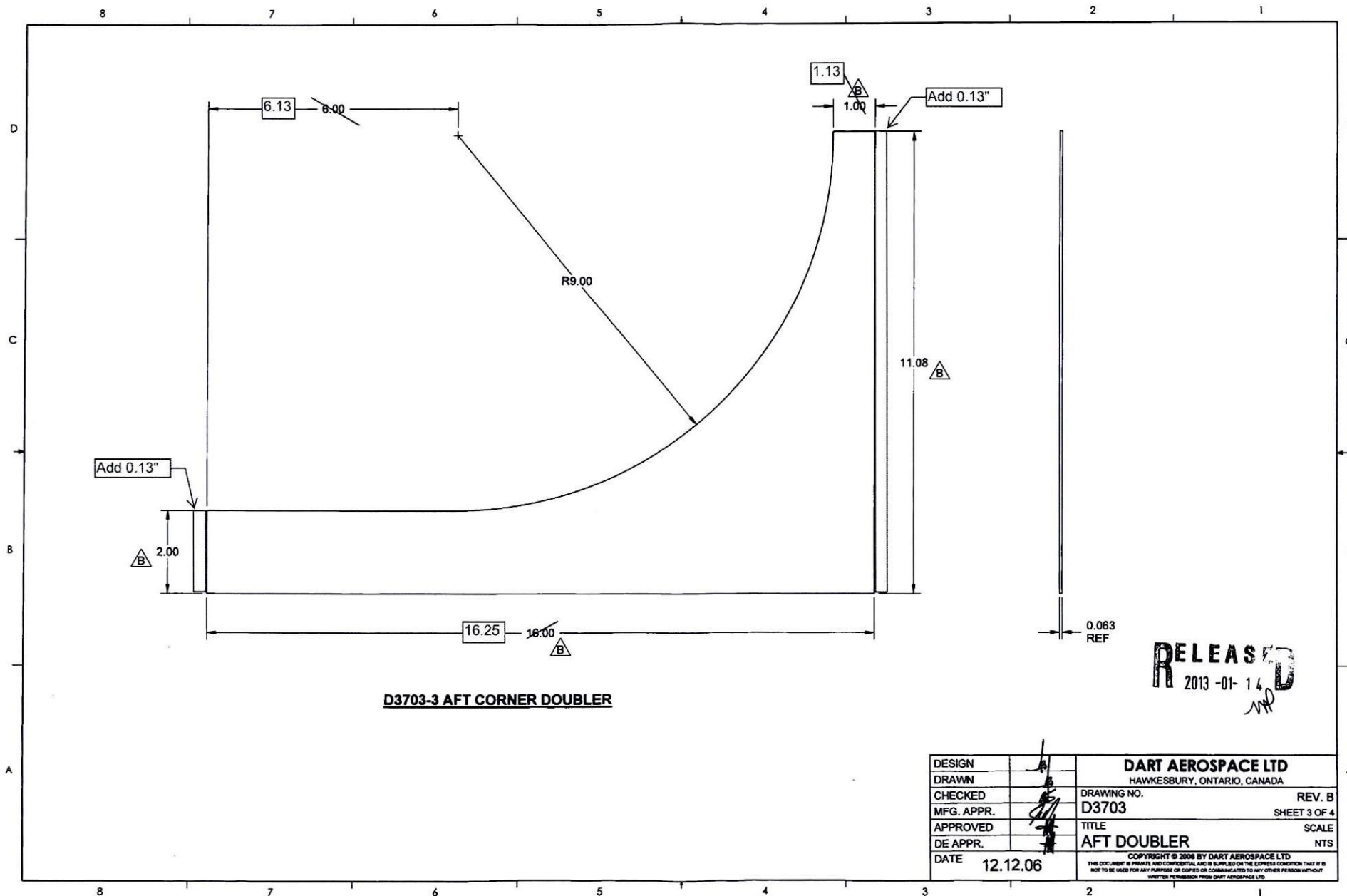
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
- 7) WEIGHT: D3703-1 = 0.56 lbs, D3703-3 = 0.23 lbs, D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

B	REVISED D3703-3/-5. REASON: PAR12-188/CIR12-4.	MB	12.12.06
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.06		

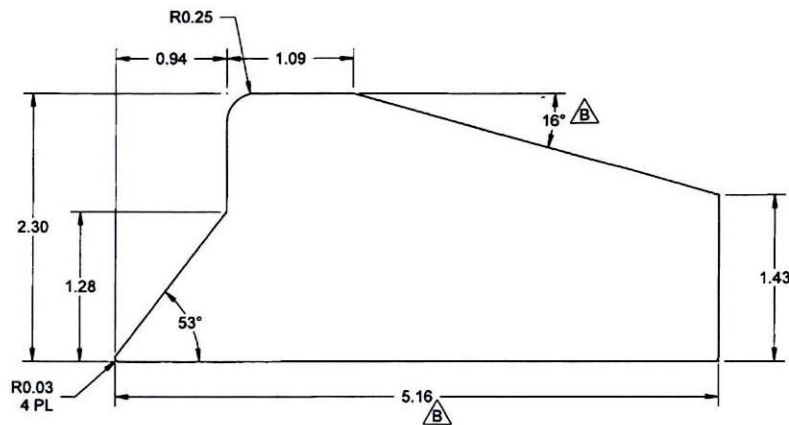
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3703	REV. B
TITLE AFT DOUBLER	SHEET 1 OF 4
SCALE NTS	

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8 7 6 5 4 3 2 1



RELEASED
 2013-01-14
MD



D3703-5 AFT CAP

RELEASED
2013-01-14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3703	REV. B
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	12.12.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-761
Page 10 of 15

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
X											D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X										D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1					X				D412-761-049	ARMREST KIT, LH
			1					X			D412-761-051	ARMREST KIT, LH
		1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1	1									X	D412-761-141	VENT KIT
1	1										204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153	BELL 204, 205, 210, 412 OEM DOOR

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Revision: **F**
Date: 16.05.26

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
			1						D3676-1	LARGE BUBBLE WINDOW
			1						D3678-1	PLACARD
			1						D3678-3	PLACARD
			1						D3678-5	PLACARD
			1						D3700-1	INBOARD WINDOW DOUBLER
			1						D3700-3	OUTBOARD WINDOW DOUBLER
			1						D3701-1	FLOOR DOUBLER
			1						D3702-1	FORWARD DOUBLER
			1						D3703-1	AFT DOUBLER
			1						D3703-3	AFT CORNER DOUBLER
			1						D3703-5	AFT CAP
			1						D3704-1	ESCUTCHEON
			1						D3704-3	ESCUTCHEON
			1						D3708-1	ANGLE
			1						D3708-3	ANGLE
			1						D3709-1	ANGLE
			1						D3709-3	ANGLE
			1						D3802-1-135	SEAL
			1						DT9458	CUTTING TEMPLATE
			26						AN3-7A	BOLT
			26						MS21042L3	NUT
			1						MS24694-C5	SCREW (OR MS24694-S5)
			1						MS24694-C13	SCREW (OR MS24694-S13)
			1						NAS43DD3-24	SPACER
			52						NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 12)

Work Order ID 147757

June 13, 2016 10:55:26 AM

147757

Page 1

Item ID: D412-761-045

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-533

Stop

NS2

Item Name: Bubble Window

Start Date: 6/13/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: OU

Date: 6/13/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	Rev E U/R <u>OK</u>	<u>16/6/13</u>							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-045	CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

JUL 27 2016

DAS
21
9-89

JUL 27 2016

DAS
21
9-89

see attachment

10



Description: LARGE BUBBLE WINDOW, LH

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